

Monday, March 13, 2017 10:45:05 AM

Item ID: D3859-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 3/14/2017 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 3/20/2017 **Req'd Qty:** 4.00

4

Customer:

Reference: SCHEDULE/S

DAS
21
9-89

Approvals:

Process Plan:

Date: MAR 13 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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158149

Monday, March 13, 2017 10:45:05 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

Start Date: 3/14/2017 **Start Qty:** 4.00 ***4***

Required Date: 3/20/2017 **Req'd Qty:** 4.00 ***/****

Reference: SCHEDULE/S

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Weld per dwg A/R S.S. rod Batch:	0.00
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130

Large Fab

Large Fab

Large Fab

Memo

1-Weld D4379-5 cups as per dwg D3859

A/R 316L stainless steel rod M134442

*****use DT9462 for welding*****

1- WELD HARDCOAT TO BAR
2059B HARDCOAT BATCH: M130145

140	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------

140

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds	0.00
--	------

Memo

150	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O	0.00
---	------

Memo

④ DYCL

H Q.L ~~17-03-24~~ 17-03-24

④ 17.03.27

④ 17.03.27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Work Order ID 158149

Monday, March 13, 2017 10:45:05 AM

158149

Page 3

Item ID: D3859-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Assembly
Start Date: 3/14/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 3/20/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULE/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>ST610</u>	0.00							
180					DAS				DAS
Packaging	Memo	0.01			6	4			41
Packaging					9-89				9-89
									MAR 27 2017
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.07							
Quality Control									

17/3/28

MAR 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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158149

Parent Item: D3859-041

D3859-041

Parent Item Name: Wearplate Assembly

Start Date: 3/14/2017

Required Date: 3/20/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC
14.04.30 as per dwg rev.b DD verified by:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4379-5		Manufactured	No			130	Each	52.0000	6	24			
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D4379-5

Wearplate Cup

OK 17/03/23

Location

Loc Qty

Loc Code

WA001

52

152420

52

24

M304S16GA

Purchased

No

100

sf

64.9700

0.85

3.4

**DAS
46
9-89**

17/03/15

M304S16GA

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

64.97

m134604

5

m136036

5.39

m136327

7.1

m136687

2.48

m136790

13

m136896

32

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

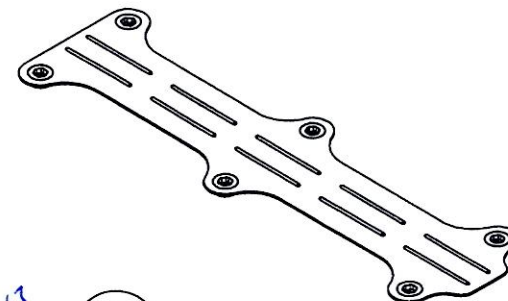
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
Root Cause				FAULT CATEGORY																																																											
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

ITEM NO.	QTY. -041	P/N	DESCRIPTION
	X	D3859-041	WEARPLATE
1	1	D3859-1	WEARPLATE
2	6	D4379-5	WEARPLATE CUP

△

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158149 MJS
17-03-13



2059B HARDCOAT
10 PL

0.06
TO
0.13
HIGH

C
SYM

0.38

1.0
TYP

3.1
TYP

1.50
REF

1.00

HARDCOAT WELD
SURFACING
REF

6 PL

1/32

6

D3859-041 WEARPLATE

D3859-1 WEARPLATE (1)

INSTALL D4379-5 FLUSH
WITH THIS SURFACE
TYP

D4379-5 WEARPLATE CUP (6) △

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

RELEASED
2014 MAR 29
ECN 14-544

APPROVED

B	D4379-5 CUP WAS D3009-3 CUP	DB	14.03.05
A	NEW ISSUE	HS	09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN	HS		
DRAWN	DB		
CHECKED	AP		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS		
DATE	14.03.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3859

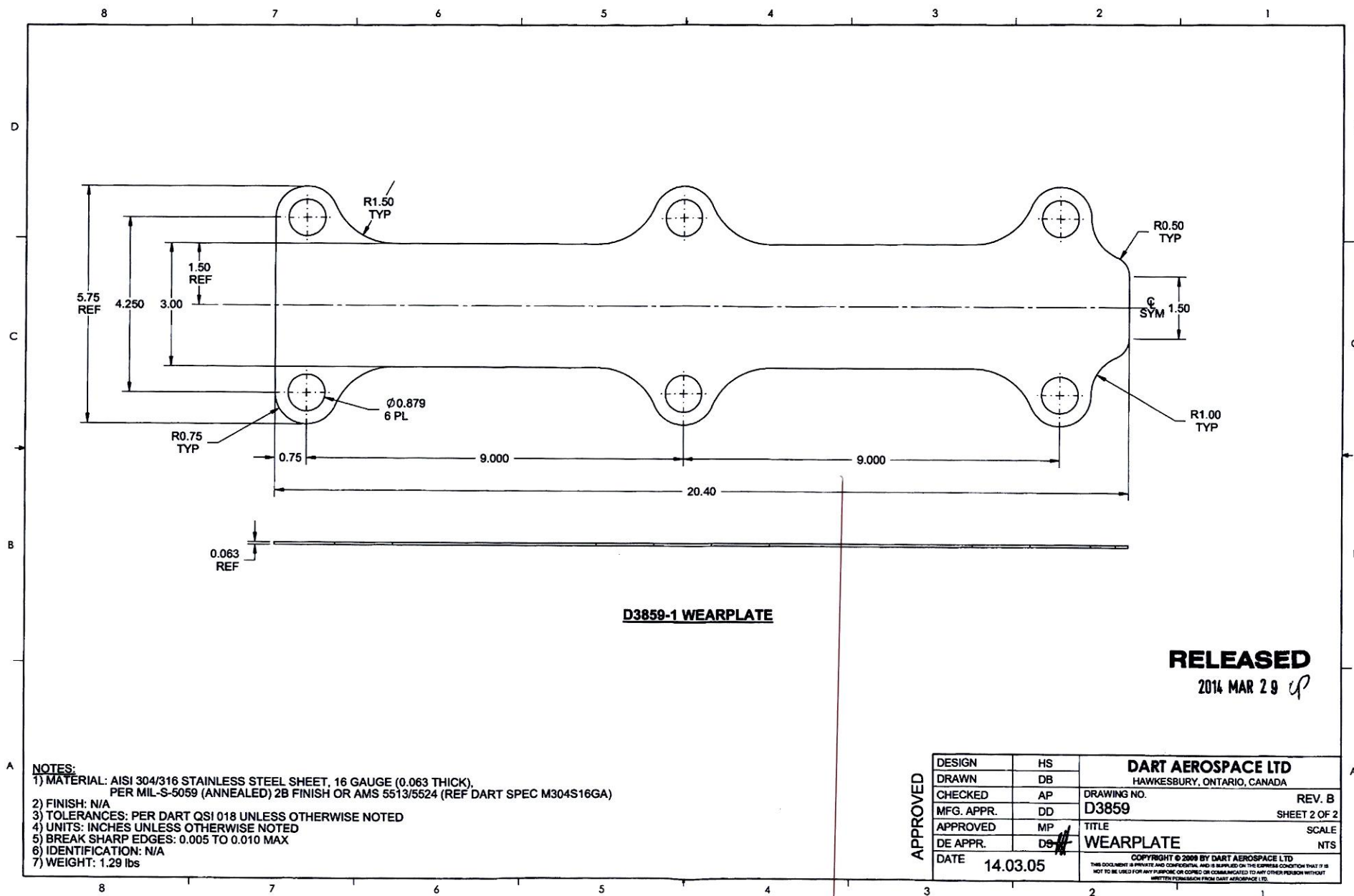
REV. B
SHEET 1 OF 2

TITLE

WEARPLATE

SCALE
NTS

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D3859-1 WEARPLATE

RELEASED

2014 MAR 29 *up*

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

APPROVED

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	DD	D3859	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
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